DART AEROSPACE LTD

| | | |
|---|---|---|
| Description: Mill Plate Asp. | Work Order: | 23878 |
| | Part Number: | D2872-043 |
| Dwg: D2872 Rev A. | Qty: | 2. |
| | | Page 1 of 2 |

| Step | Location | Procedure | By | Date | Qty |
|---|---|---|---|---|---|
| 1 | DC | Issue Traveler | | | |
| 2 | MV | Cut Blanks: .750" x .375" x 3.700" Long. Mat: 6061T6 QQ-A-225/8 QQ-A-200/8 (M6061T6B.750x.375) Batch: M7321 | | 05.07.25 | 2 |
| 3 | MV | Machine as per Folio FA548. Dwg D2872. | | 05/07/26 | 2 |
| 4 | QC2 | Inspect Parts as they come off the CNC Machine. | | 05/07/26 | 2 |
| 5 | QC8 | Second Check. ENGINEERING APPROVAL | | 05.07.27 | 2 |
| 6 | MV | Deburr. | | 05/07/26 | 2 |
| 7 | GA | C'Sink as per Dwg D2872. | | 05.07.28 | 2 |
| 8 | QC5 | Inspect Work to Step #7 | | 05.07.28 | 2 |
| 9 | FP | Chemical Conversion Coat as per Spec QSI 005 4.1. | | 05.07.28 | 2 |
| 10 | QC3 | INSPECT Re Chemical Conversion. | | 05.07.28 | |

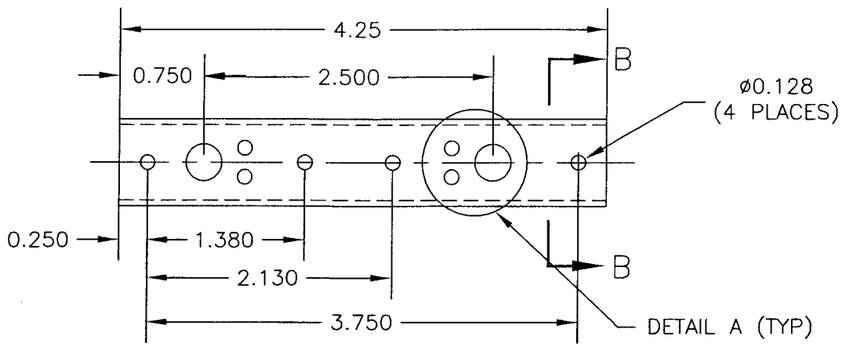
| Rev | Date | Change | Revised By | Approved |
|---|---|---|---|---|
| | | | | |

DART AEROSPACE LTD

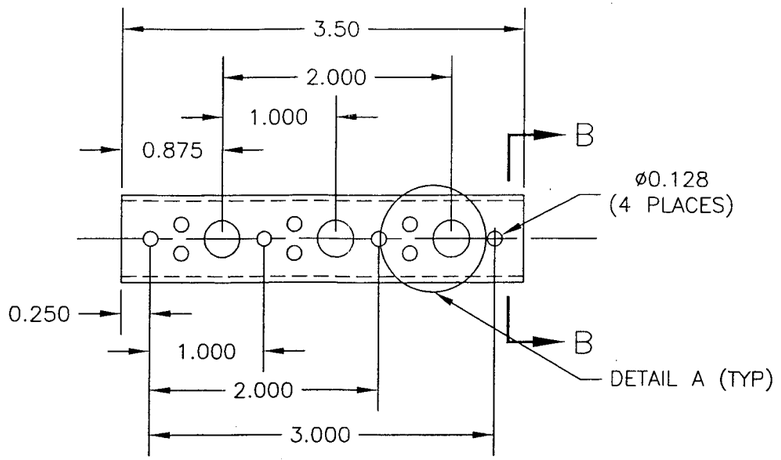
| | | |
|---|---|---|
| Description: | Work Order: | |
| | Part Number: | |
| Dwg: | Qty: | |
| | | Page 2 of 2 |

| Step | Location | Procedure | By | Date | Qty |
|---|---|---|---|---|---|
| 1 | DC | Issue Traveler | | | |
| 11 | GA. | Pick. | | | |
| | | Qty Part # Desc Batch | | | |
| | | 3 MS21086L5 NUT Plate HL8064 | | 05/07/02 | 2 |
| | | 6. MS20426AD4-5 Rivet M3022 | | | |
| | | Assemble as per Dwg D2872 | | | |
| 12. | QCS. | Inspect Work to Step #11. | | 05/07/02 | 2 |
| 13 | ST | Identify & Stock. | | 05/07/02 | 2 |
| 14 | AC | Cost/Part 31.37 31.37 | SJC | 05-08-02 | 2 |
| 15 | DC | Close w/o. Level 21 | | 05/08/02 | 2 |

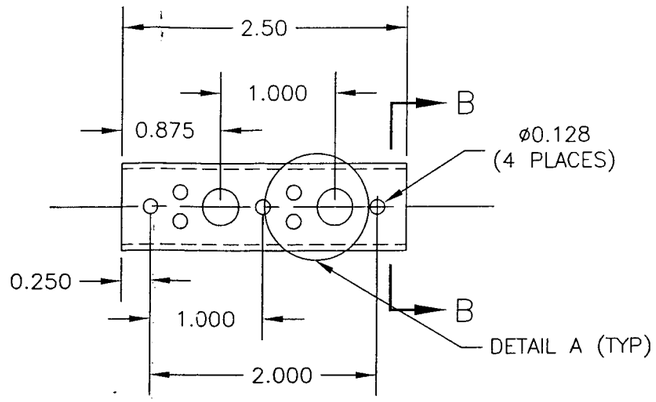
| Rev | Date | Change | Revised By | Approved |
|---|---|---|---|---|
| | | | | |



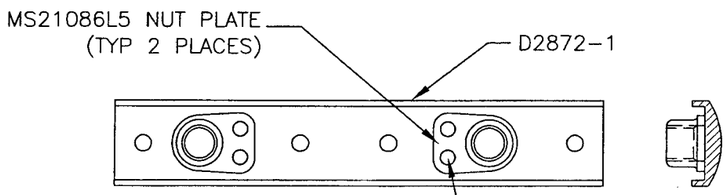

**D2872-1**



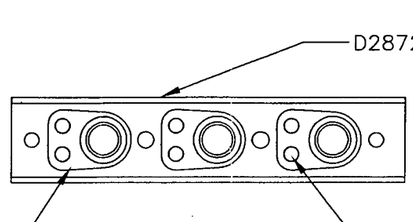

**D2872-3**



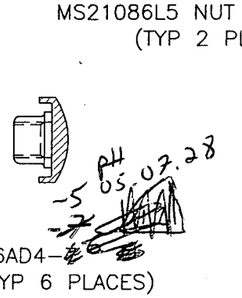

**D2872-5**

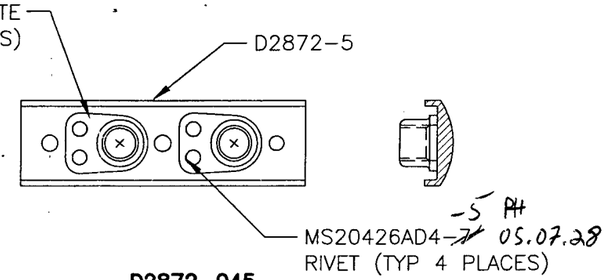



**D2872-041**




**D2872-043**




**D2872-045**

D2872-1/-3/-5 RADIUS BLOCK

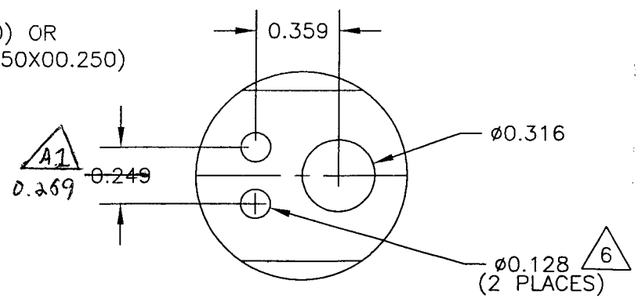
1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B0.750X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B0.750X00.250)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE INCHES
5) BREAK ALL SHARP EDGES 0.010 TO 0.020
6) C'SINK CURVED SIDE ø0.225 x 100°

D2872-041/-043/-045 NUT PLATE ASSEMBLY

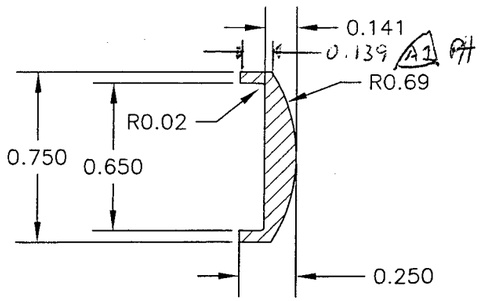
1) INSTALL MS21086L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-5 RIVETS
PH 05.07.28

**D2872-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

| -041 | -043 | -045 | PART NUMBER | DESCRIPTION |
|---|---|---|---|---|
| X | | | D2872-041 | NUT PLATE ASSEMBLY |
| | X | | D2872-043 | NUT PLATE ASSEMBLY |
| | | X | D2872-045 | NUT PLATE ASSEMBLY |
| | | | | |
| 1 | | | D2872-1 | RADIUS BLOCK |
| | 1 | | D2872-3 | RADIUS BLOCK |
| | | 1 | D2872-5 | RADIUS BLOCK |
| 4 | 6 | 4 | MS20426AD4-5 | RIVET |
| 2 | 3 | 2 | MS21086L5 | NUT PLATE |




DETAIL A (SCALE 2:5)




SECTION B-B (SCALE 2:5)

PRELIMINARY ISSUE

CHANGE RIVET SIZE

| | | | |
|---|---|---|---|
| A1 | PH | 05.07.06 | HOLE SPACE WAS 0.249, NOW 0.269 |
| A | | 05.05.06 | NEW ISSUE |

| | | |
|---|---|---|
| DESIGN: PH | DRAWN BY: PH | DART AEROSPACE LTD, HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2872 — REV. A — SHEET 1 OF 1 |
| DATE: 05.05.06 | | TITLE: RADIUS BLOCK — SCALE: 4:5 |

| DART AEROSPACE LTD | Work Order: | 23878 |
|---|---|---|
| Description: RADIUS BLOCK | Part Number: | D2872-3 |
| Inspection Dwg: D2872 Rev: A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☑ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 3.50 | ±.030 | 3.501 | ✓ | | | |
| 2.000 | ±.005 | 2.000 | ✓ | | | |
| 1.000 | ±.005 | 1.000 | ✓ | | | |
| 0.875 | ±.005 | 0.875 | ✓ | | | |
| 0.250 | ±.005 | 0.251 | ✓ | | | |
| 1.000 | ±.005 | 0.999 | ✓ | | | |
| 2.000 | ±.005 | 2.000 | ✓ | | | |
| 3.000 | ±.005 | 3.000 | ✓ | | | |
| Ø0.128 | +.005 −.000 | Ø0.129 | ✓ | | | |
| 0.269 | ±.005 | 0.270 | ✓ | | | |
| Ø0.316 | +.005 −.000 | Ø.316 | ✓ | | | |
| 0.750 | ±.010 | 0.749 | ✓ | | | |
| 0.650 | ±.010 | 0.647 | ✓ | | | |
| 0.139 | ±.010 | 0.140 | ✓ | | | |
| 0.141 | ±.010 | 0.140 | ✓ | | | |
| 0.250 | ±.010 | 0.249 | ✓ | | | |
| R0.02 | ±.030 | R0.025 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | ML |
|---|---|
| Date: | 05/07/26 |

| Audited by: | BK |
|---|---|
| Date: | 05.07.26 |

| Prototype Approval: | PH |
|---|---|
| Date: | 05.07.26 |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | KJ/RF | |